

JAPAN

EDICT OF GOVERNMENT

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JIS B 6608 (1983) (English): Safety standards for construction of veneer lathes

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The citizens of a nation must honor the laws of the land.

Fukuzawa Yukichi

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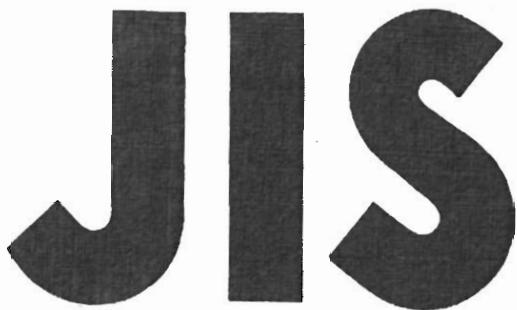


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JAPANESE INDUSTRIAL STANDARD

Safety Standards for Construction
of Veneer Lathes

JIS B 6608-1983

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standard in Japanese is to be evidence

JAPANESE INDUSTRIAL STANDARD

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Safety Standards for Construction of Veneer Lathes B 6608-1983

1. Scope

This Japanese Industrial Standard specifies the construction for safety, instruction manuals, inspection data sheets, and marking on the veneer lathes⁽¹⁾ (including the lathe charger.).

Note ⁽¹⁾ Refer to JIS B 0114.

2. Definitions

For the purposes of this standard the following definitions apply.

- (1) log carrying-in device In a lathe charger, a mechanism which carries logs from a pretreatment process department into a log centering device.
- (2) log centering device In a lathe charger, when a log is supplied to the veneer lathe, a mechanism which determines the centre of rotation of the log for the purpose of its most effective utilization.
- (3) log supplying device In a lathe charger, a mechanism which supplies logs by gripping them securely.
- (4) cushion start When the log supplying device is to be actuated, a method to obtain a set speed by gradually acceleration. This is also termed as the "soft start".
- (5) cushion stop When the log supplying device is to be stopped, a method to stop by gradual deceleration. This is also termed as the "soft stop".
- (6) log cutting device In the veneer lathe, a mechanism which cuts logs, gripping them securely, and is composed of the following:
 - (a) Planer Table A table on which knives, nose bars and others are attached for cutting logs.
 - (b) Spindle When a log is gripped and cut, an axle which forms the centre of rotation.
 - (c) Bend Preventing Device At the time of cutting a log, a device to prevent the bend of the log generated when it is pushed by the knives and the spindles, as its diameter gradually becomes smaller.

Applicable Standard:

JIS B 0114-Glossary of Terms for Wood Working Machinery

Reference Standards:

JIS B 6507-General Code of Safety for Wood Working Machinery

JIS B 6542-Veneer Lathes

(7) interlock For the purpose of allowing the machine and devices to work safely and efficiently, a mechanism which controls the inter-related motions of those devices.

3. Construction for Safety

3.1 Log Carrying-in Device The log carrying in device shall be as follows:

- (1) The carrying conveyor shall be capable of carrying logs safely and securely.
- (2) The conveyor for carrying to the centering part shall be so constructed that it stops immediately when the operator detaches his hand from its operating switch.

3.2 Log Centering Device The log centering device shall be so constructed that logs will not fall down easily from vee blocks for catching them.

3.3 Log Supplying Device The log supplying device shall be as follows:

- (1) The device shall be so constructed that logs can be gripped securely by means of such mechanism as to prevent the pressure drop inside a cylinder, and further shall be provided with an alarm device to inform of it when the pressure has begun to decrease.
- (2) The device shall be equipped with the cushion start and cushion stop mechanisms to prevent logs from falling down due to the reaction caused at the time of the start or stop of the device when supplying logs.

3.4 Log Cutting Device The log cutting device shall be as follows:

- (1) The device shall be so constructed that the knives are attached and detached securely and easily.
- (2) The device shall be so constructed that the adjustment and cleaning of the knife opening, and others are made safely and easily.

3.5 Location for Operation Control Board The operation control board shall be located at a position where the operator can sufficiently overlook the front and back of his process.

3.6 Danger Prevention at Time of Interruption of Electric Source Supply and Restarting The danger prevention at the time of interruption of electric source supply and the restarting of veneer laths shall be as follows:

- (1) The safety devices shall be so designed that, in case of power service interruption, a state of the device relating to the gripping of logs and holding of knives by oil pressure, the opening and closing of the knife opening part of a knife holder and the like is maintained in the same state as before the power interruption, or otherwise the device acts to the safety side.

(2) The veneer lathes shall be provided with a mechanism which prevents their automatic restarting, even if the power source circuit is restored again after the power interruption.

3.7 Interlock The interlock shall be as follows:

- (1) The vee blocks for centering under automatic running shall never be lifted when the cylinder for pushing logs laterally is moving forward or backward and the log supplying device lies on the side of the log centering V-blocks apart from its intermediate stop position.
- (2) The log supplying device at the centering position shall advance to the veneer lathe side only when the log centering V-blocks are located at their lowest position.
- (3) The log supplying device shall stop at an intermediate stop position however the push button for advancing the device is repeatedly pushed, if the spindle of the veneer lathe is not located at the limit of backward movement or if the bend preventing device is not located at its uppermost position.
- (4) The log supplying device at an intermediate stop position shall never advance to the veneer lathe side, if the spindle of the veneer lathe is not located at the limit of backward movement or if the bend preventing device is not located at its uppermost position.
- (5) The log supplying device shall never release the log even though the push button for releasing logs is pushed, if the device itself is not located at the centre of the spindle of the veneer lathe, if the spindle is not advancing, or if the gripping of logs is not completed.
- (6) The log supplying device shall never return to the log centering device side from the veneer lathe side except when the log gripping device is located in a safety range.
- (7) The veneer lathes shall be provided with a mechanism which prevents the knife holder from coming into contact with the spindle by the application of their forward and backward movement limiting switches and others.
- (8) During operation of switches near at hand for opening and closing the knife opening part of the knife holder, the lathe veneer shall be furnished with such a mechanism as the rotation of spindles, the opening and closing of the knife opening part and the forward and backward movement of cutter holders can not be operated on the operation control board.

3.8 Working Floor The working floor shall be as follows:

- (1) On the working floor of the operation control board, handrails and the like shall be provided.
- (2) A working floor shall be provided on which the cleaning of knife opening part and the adjustment of scribing knives are conducted.
- (3) Slip preventing treatment shall be applied on the surface of the working floors.

3.9 Cover for Rotating Parts Covers shall be provided on the portions in which operators are liable to be caught in due to their contact with parts, such as gears, pulleys and belts, during their operation.

4. Instruction Manual

The veneer lathe shall be furnished with an instruction manual, in which are enumerated the necessary matters for securing safety such as the type, specifications, construction, tools, operations, maintenance, inspection, arrangement, installation and others.

5. Inspection Data The veneer lathe shall be furnished with inspection data sheets (inspected items and their results) relating to safety.

6. Marking

The veneer lathe shall be marked with the following information on a conspicuous place in an indelible way:

- (1) Manufacturer's name
- (2) Year and month of manufacture and serial number
- (3) Type
- (4) The maximum length and the maximum diameter (lathe charger)
- (5) Length and swing of knife holding face (veneer lathe)
- (6) Diameter of spindle
- (7) The maximum speed of rotation of spindle
- (8) Other matters particularly necessary for securing safety

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